

Date: Monday, 7/9/2007 11:47:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TOW RING	
Job Number	: 33362		Part Number	: D2968043UP	
Estimate Number	: 12928		Drawing Number	: D2968	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 7/9/2007	S.O. No. : N/A	Drawing Revision	: B1 C PH 07-07-09	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/20/2007 Qty: 12 Um: Each	
Previous Run	: N/A				
Written By	: JLM 07.07.09				
Checked & Approved By	: JLM 07.07.09				
Comment	: Est Rev:A New Issue 07-07-04 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	33362A	STEM	 Comment: Sub-Component STEM D2968-3 B 33362-A
2.0	33362B	RING	 Comment: Sub-Component RING D2968-5 B 30275
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	 Comment: LARGE FABRICATION RESOURCE 1 Weld D2968-3 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-043 Batch: M102421
4.0	QC9	VISUAL WELDING INSPECTION	 Comment: VISUAL WELDING INSPECTION
5.0	QC5	INSPECT WORK TO CURRENT STEP	 Comment: INSPECT WORK TO CURRENT STEP
6.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH	 Comment: Sub-Contracting PURCHASING Issue P/O: 4547
Description: D2968-043 to heat treat to ultimate tensile strength 125ksi as per Dwg D2968 Conformity sheet required			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:02 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33362

Part Number: D2968043UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

Issue P/O: 4548

c 207/09/10

Cad Plate per QQ-P-416F Class I Type II

(12)

Conformity sheet required

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

207/09/03 (12)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207/09/09 (12) counter

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

207/09/09 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/10/11

Job Completion



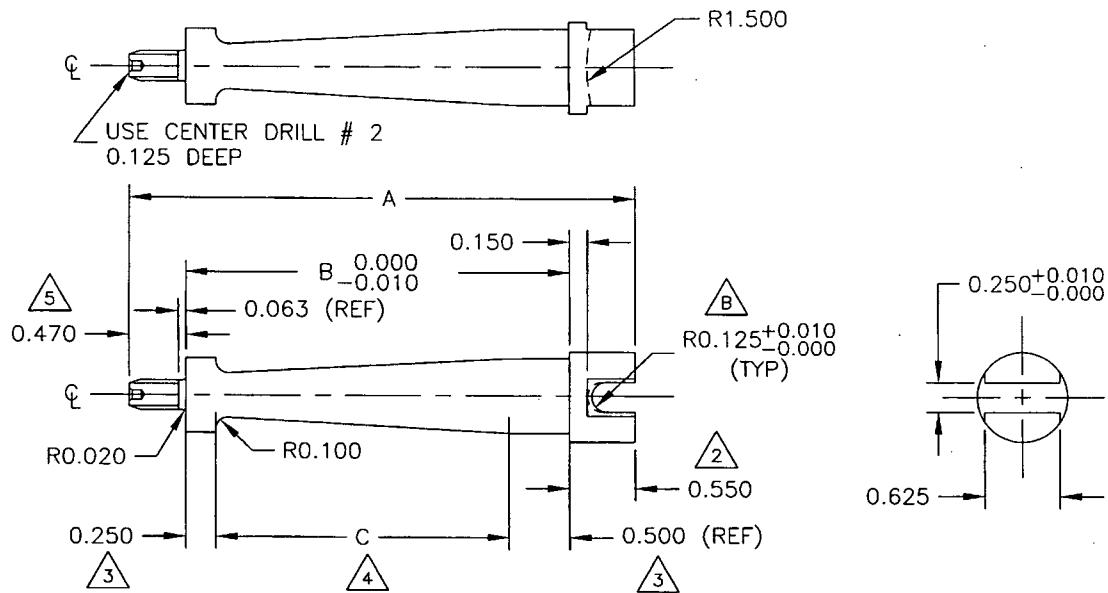
U 207/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

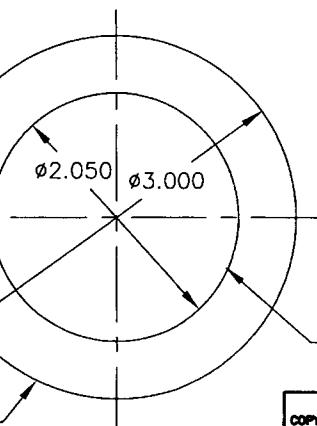


D2968-1 / -3 STEM

D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D.
TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

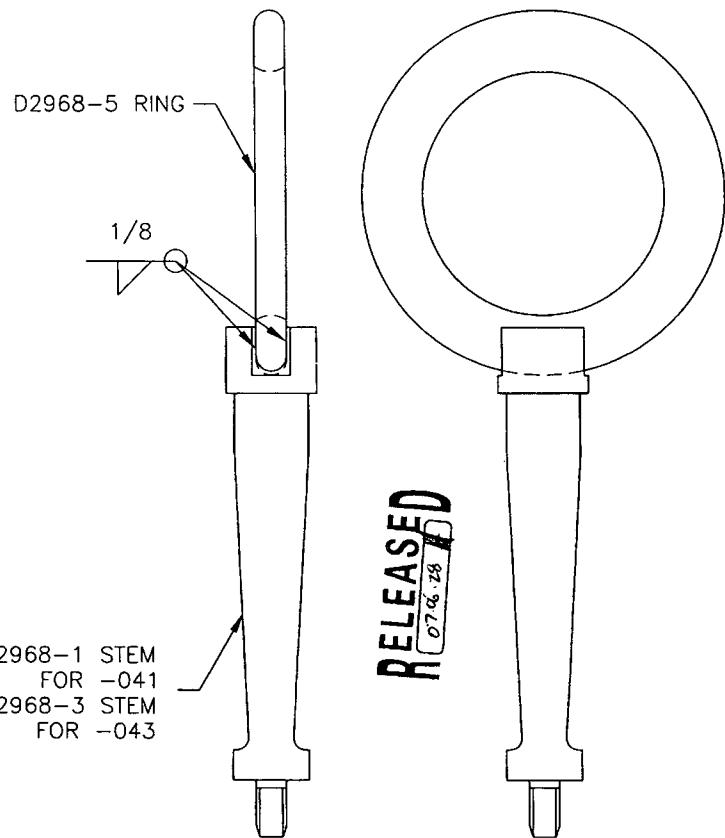
NO. *VER 3.00*
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B
SHOP COPY
RETURN TO
ENGINEERING



D2968-5 RING

D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA		
DESIGN	DRAWN BY	REV. C
CHECKED	APPROVED	SHEET 1 OF 1
DATE	TITLE	SCALE
07.04.17	TOW RING	1:1

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**Placage
Manco Domplex
Electroplating**

Tél.: (514) 355-7867 / 1-877-355-7867

Siège social / Head Office Plan 1
4660 Hickmore 4670 Hickmore
Ville St-Laurent, Québec Ville St-Laurent, Québec
H4T 1K2 Fax: (514) 355-5991
Fax: (514) 355-8750

Plan 2
8001 Larrey
Anjou, Québec
Fax: (514) 354-2937

**BON DE LIVRAISON
PACKING SLIP**

V S _____
E O _____
N L _____
D D DART Aerospace b6
U T _____
A O _____

EXS
SHIP
DPT
EIT
A
Dart Investments Ltd
1270 Meadow St
Markham, ON K0A 1K7

AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON
NO RECLAMATION AFTER 5 DAYS FROM DATE OF DELIVERY

NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY
COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE Verte / GREEN COPY: CONFIRMATION D'EXPÉDITION / SHIPPING CONFIRMATION
COPIE JAUNE / YELLOW COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE Verte / GREEN COPY: CONTAINERS
COPIE ORANGE / ORANGE COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

BON DE LIVRAISON
105843

MANCO DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: 514-355-7867
Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

19013

Dart Aerospace LTD
Client / Customer
P04548
Votre # de commande / Your purchase order #

D2968-043 uP B3336
de la pièce / part #
105843
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Renault</u>	Date, équipe / Date, shift <u>Sept 28, 2007</u>
Placage / Plating <u>QQP 416F</u>	Class 1 Type II
Quantité totale / Total quantity <u>12</u>	Quantité inspectée / Inspected quantity <u>12</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D. H.C.D.	Moy. / aver. <u>0.0005</u>
Coulisses, taches / Leach, spots <u>no</u>	Rugosité / Roughness <u>no</u>
Quantité approuvée / Approved quantity <u>12</u>	Quantité rejetée / Rejected quantity

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX



VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 90865-1

HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

09/26/2007

MM/DD/YYYY

PAGE: 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT QC

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
09/26/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00004548		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2968-043	UP B33362 Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5 MATERIAL: 4130	EA	12	12	0
02	MC	MINIMUM CHARGE		1	1	0
				<i>SP 07/10/03</i>		

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT
TREATING

RELEASE NOTE



GST No.: R105468102

OAK 90865-1

2009 WYECROFT ROAD, UNIT B QUEBEC DIVISION
OAKVILLE, ONTARIO 7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA L6J 6J4 CANADA H4S 1C5
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CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

09/26/2007
MM / DD / YYYY

PAGE: 1

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT QC

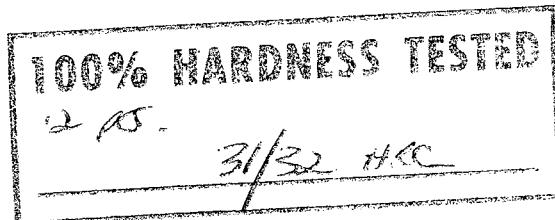
H4T 1K2

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/26/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00004547		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS	
					EA	12
20068-043	UP B33362					

Process Specifications: Procedure: 4047
HEAT TREATED TO 125 KSI MIN.
100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5
MATERIAL: 4130



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.


Authorized Q.C. Inspector



MICRO BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
PLASMA AND OTHER COATINGS

HEAT TREATING